

Date: Wednesday, 3/28/2007 12:40:08 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	INNER FWD SADDLE		
Job Number	31529			Part Number	D5953		
Estimate Number	11079			Drawing Number	D5953 REV B		
P.O. Number	N/A			Project Number	N/A		
This Issue	3/28/2007 S.O. No. N/A			Drawing Revision	B		
Prsh Rev.	NC			Material	N/A		
First Issue	N/A			Due Date	4/15/2007 Qty: 6 Um: Each		
Previous Run	28080						
Written By							
Checked & Approved By							
Comment	Est Rev.E	Re-Format	05-11-29	JLM			
	Est Rev.f	ecn 826	06.12.06	EC			

Additional Product

Seq. #:	Machine Or Operation:	Description:	
1.0	D6101007	7075-T7351 8.25X7.75X2.5	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 6.0000 Each(s) D6101-007(7075-T7351) Size 2.50" x 7.50" X 8.25" (Grain along 7.50") Batch: N25355	
			JL/JF 07/04/03 ⑥
2.0	HAAS3	HAAS CNC VERTICAL MACHINING #3	
		Comment: HAAS CNC VERTICAL MACHINING #3	
		1-Machine as per folio D5953, Ensure Batch Number is entered	
		2-Machine Keyway	
		3-Deburr & Tumble	
			JL/JF 07/04/03 ⑥
3.0	QC1	INSPECT ALL DIM TO DIM SHEET	
		Comment: INSPECT ALL DIM TO DIM SHEET	
			JL/JF 07/04/03 ⑥
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	
			ML 07/04/05 ⑥
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1	
		Chemical Conversion Coat as per QSI 005 4.1	
			M.R 07/04/09

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/04/12
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07.03.03	2	POCKETING AROUND SADDLE TO - SKIDTUBE HOLES OFFSET 0.050" SMALLER ALL AROUND. - CAUSE IS CUTTER COMP.	<i>[initial]</i>	ACCEPTABLE Deviation.	N/A	<i>[initial]</i> 070305	<i>[initial]</i> 07.04.03	<i>[initial]</i> 070405

NOTE: Date & initial all entries

DART AEROSPACE LTD

Work Order:

31529

Description: Inner Fwd Saddle

Part Number:

D5953

Inspection Dwg: D5953

Rev: B

Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.439"	.439"	.439"	.439"		
B	1.745	1.755		1.751"	1.751"	1.751"	1.751"		
C	5.245	5.255		5.250"	5.250"	5.250"	5.250"		
D	6.995	7.005		7.000"	7.000"	7.000"	7.000"		
E	5.745	5.755		5.748"	5.748"	5.748"	5.748"		
F	4.745	4.755		4.749"	4.749"	4.749"	4.749"		
G	0.313	0.318		.314"	.314"	.314"	.314"		
H	1.522	1.532		1.528"	1.528"	1.528"	1.528"		
I	3.048	3.058		3.055"	3.055"	3.055"	3.055"		
J	4.575	4.585		4.580"	4.580"	4.580"	4.580"		
K	0.313	0.318		.314"	.314"	.314"	.314"		
L	0.495	0.505		.500"	.500"	.500"	.500"		
M	0.490	0.510		.510"	.500"	.500"	.500"		
N	1.615	1.635		1.634"	1.625"	1.625"	1.625"		
O	7.990	8.010		7.999"	7.999"	7.999"	7.999"		
P	2.240	2.260		2.260"	2.260"	2.260"	2.260"		
Q	0.307	0.312		.310"	.310"	.310"	.311"		
R	0.760	0.765		.765"	.765"	.764"	.765"		
S	0.490	0.510		.502"	.500"	.493"	.503"		
T	1.375	1.395		1.381"	1.386"	1.382"	1.387"		
U	2.000	2.020		2.010"	2.010"	2.010"	2.010"		
V									
W									
X									
Y									
Z									
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by:

JF

Date: 07/04/03

Audited by:

2nd

Date: 07/04/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART AEROSPACE LTD	Work Order:	31529
Description: Inner Fwd Saddle	Part Number:	D5953
Inspection Dwg: D5953	Rev: B	Page 1 of 1

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V									
W									
X									
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AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

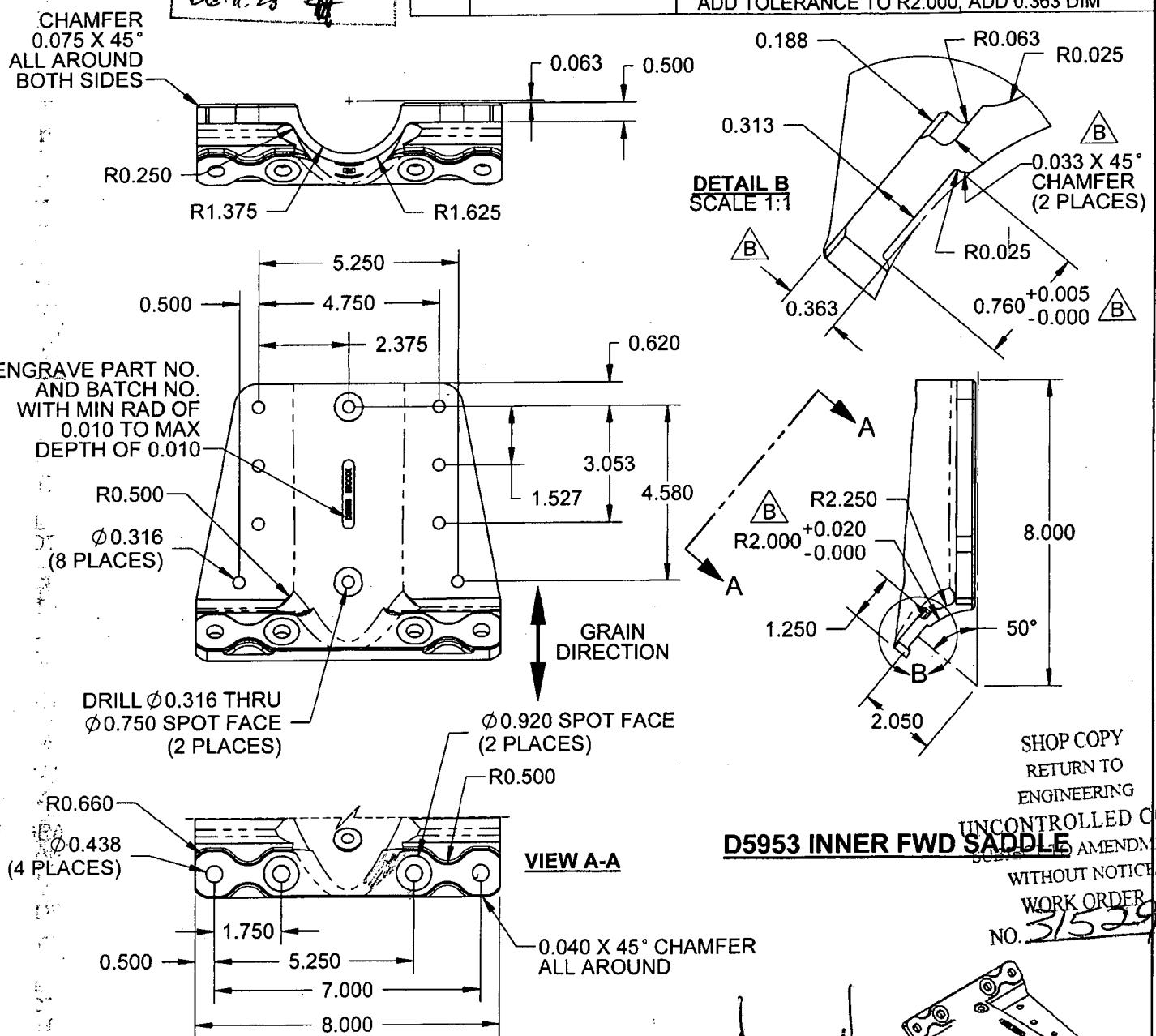
Measured by:	J.F.	Audited by:	<i>JKL</i>
Date:	07/04/04	Date:	07/04/05

Rev	Date	Change	Revised by	Approved
A	99.04.19	New Issue	RF	
B	02.12.13	Reformat; Added Dim. T-U & DT8682, DT8686 & DT8696 A/B	KJ/RF	
C	06.12.06	Dimensions L,N,P revised	KJ/EC	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CE</i>	APPROVED <i>HT</i>	DRAWING NO. D5953	REV. B SHEET 1 OF 1
DATE 06.11.07		TITLE INNER FWD SADDLE	SCALE 1:4

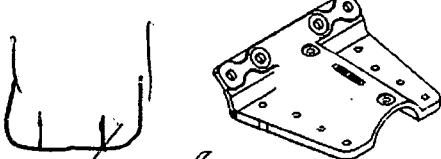
REV	DATE	DESCRIPTION
A	97.05.06	NEW ISSUE
B	06.11.07	INCORPORATE DEO 9102, DEO 9079; ADD 0.363 DIMENSION; $\phi 0.316$ WAS $\phi 0.313$; ADD TOLERANCE TO R2.000; ADD 0.363 DIM



NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 PER QQ-A-250/12
(MAKE FROM D6101-007 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.010 TO 0.020

ISOMETRIC VIEW
SCALE 1:8



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